

Work Order ID 51335

August 19, 2009 11:21:31 AM



Page 1

Item ID:	D3838-042	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly (Basket Lid, RH)					
Start Date:	08/19/2009	Start Qty:	2.00		Cust Item ID:	
Required Date:	08/25/2009	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>09-08-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3838	Rev A

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3838-2 and D3838-3 rib as per dwg D3838-2- c'sink hole as per dwg-3- remove identification markings-4- deburr								

SAD 09-08-20

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

=) 8 09/08/20

(2)

42

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Page 2

Item ID: D3838-042 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Basket Lid, RH)
Start Date: 08/19/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 08/25/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Large Fab	Large Fab	0.00							
Large Fab	Memo 1- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 <input type="checkbox"/> A/R ER316 S.S. Rod Batch: <u>H108160</u> <input type="checkbox"/> 2- grind weld flush where indicated on dwg D3838 <input type="checkbox"/> 3- weld D3759-1 bushing as per dwg D3838 <input type="checkbox"/> 4-	0.00							
130  QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

Handwritten notes:
09-08-24
P 09-08-24
27 8 02/08/24
-042
+2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date:	08/25/2009	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00				<u>(2)</u>			
Packaging									
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SAD 09-08-25

09/08/26 HJ

PL 09-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

August 19, 2009 11:21:31 AM

Work Order ID: 51335

Parent Item: D3838-042RevA

Parent Item Name: Rib Assembly (Basket Lid, RH)



Start Date: 08/19/2009

Required Date: 08/25/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA 		Manufactured	No			100	Each	58.0000	2.0000			
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

58

50000

22

51136

36

120

f

1,352.362 2.1720

2 PD 09-08-24

✓ M304TS0.750W.065

Purchased

No



304 SQ Tube .75x.75x.065W



SAD 09-08-20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

6.307103691

112051

-0.7368363

112263

7.04394

Main Warehouse

WA

1346.0554

112263

1.6735

112344

344.3819

112398

1000

2.1720

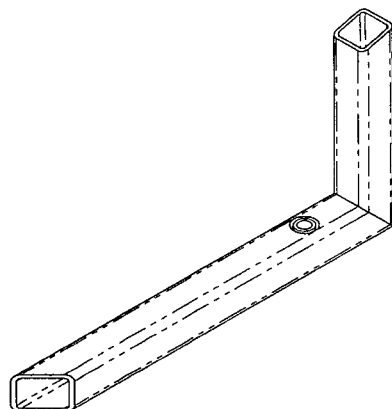
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

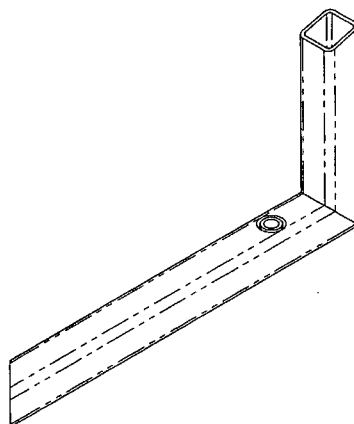
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D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51325

MF 09-08-14

RELEASED
08/10/08

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

A	NEW ISSUE		MB	08.10.08
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3838 TITLE RIB ASSY (BASKET LID)		
DRAWN				
CHECKED				
MFG. APPR.				REV. A
APPROVED				SHEET 1 OF 1
DE APPR.				SCALE
DATE	08.10.08			NTS
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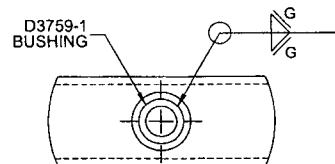
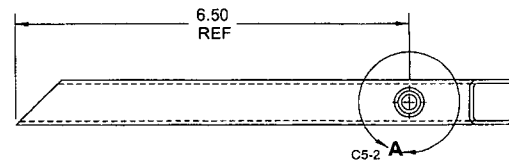
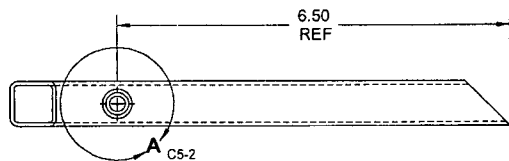
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

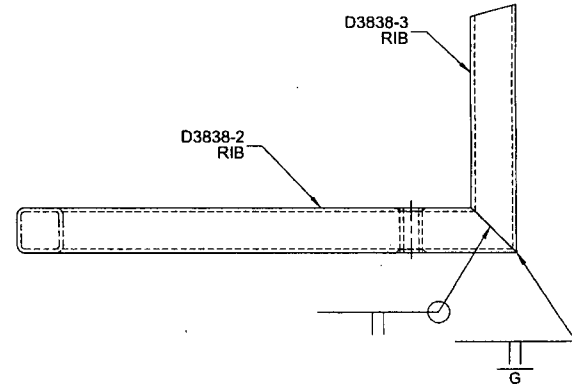
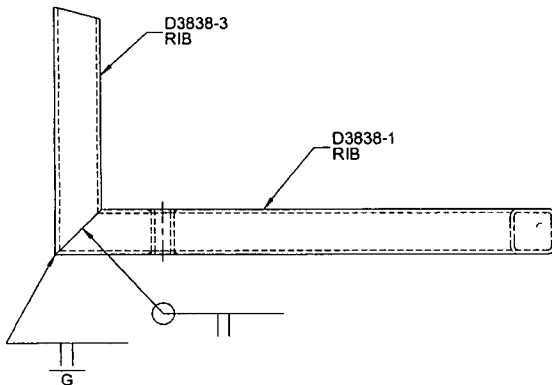
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DETAIL A
D2-2
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED
08/11/18

51335

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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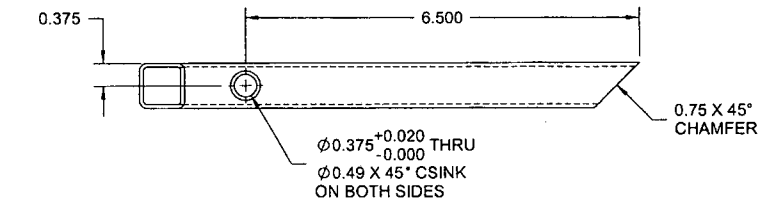
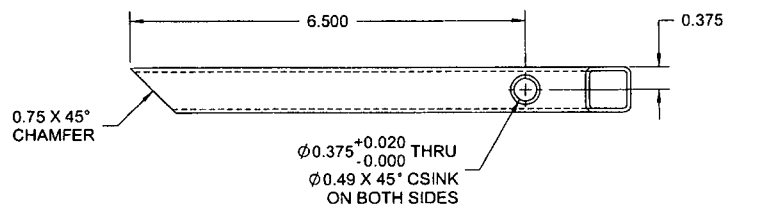
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8 7 6 5 4 3 2 1

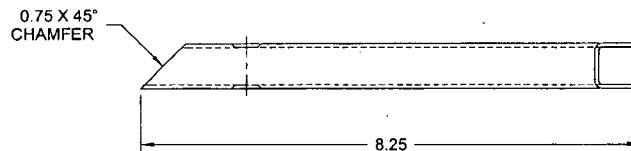
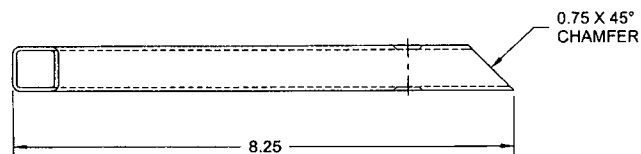
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D



C

C

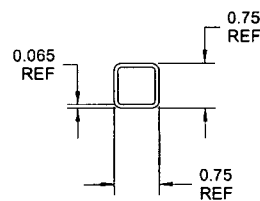
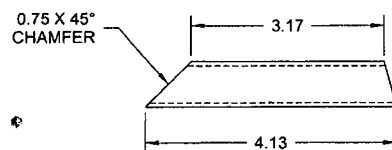


D3838-1 RIB

D3838-2 RIB

B

B



D3838-3 RIB

TYPICAL SECTION VIEW

51335

RELEASED

A

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3838	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE RIB ASSY (BASKET LID)	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	DATE 08.10.08	
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8 7 6 5 4 3 2 1

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